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ABSTRACT OF THE DISCLOSURE

A patient support apparatus comprises a base frame, a patient support coupled to the base frame, a plurality of casters each having a sleeve, and a plurality of caster mounting tubes having an interior configured to receive the sleeve of a caster. The caster mounting tubes have a plurality of external side walls, a first generally planar side wall abutting the base frame. Each of the plurality of caster mounting tubes are connected to the base frame by welds located adjacent the first side wall.

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[illegible]